

Date: Monday, 2/19/2007 9:35:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 30763	Part Number	: D3484041
Estimate Number	: 12364	Drawing Number	: D3484 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/19/2007 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 2/26/2007 Qty: 5 Um: Each
Previous Run	: 27214		
Written By	: <u>JA 07.02.19</u>		
Checked & Approved By	: <u>JA 07.02.19</u>		
Comment	: Est Rev A New Issue 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34841	BASE, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

BASE, LH

Batch: B3077007/04/10 3

2.0	D34843	FACE, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

FACE, LH

Batch: B3077207/04/10 3

3.0	D34845	CONE, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

CONE, LH

Batch: B3077407/04/10 3

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig

A/R AL ROD Batch: M102756

2-Buff & Smooth Welds to mating surfaces

07/04/11 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 9:35:12 AM
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Process Sheet

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Drawing Name: TAIL LIGHT FAIRING

Job Number: 30763

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-04-11 (3)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-04-11 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-R 07/04/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SK 07/04/11 (3)

9.0

MS20426AD33

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

Batch: M19099

SK 07/04/11 (3)

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

ANCHOR NUT

Batch: M19633

SK 07/04/11 (3)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

07/04/11 3 PAIRS

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/04/12 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 9:35:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 30763

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M103706



(3x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R

07/04/12

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/12 (1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-141 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

07/04/12 (1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/12

Job Completion



07/04/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

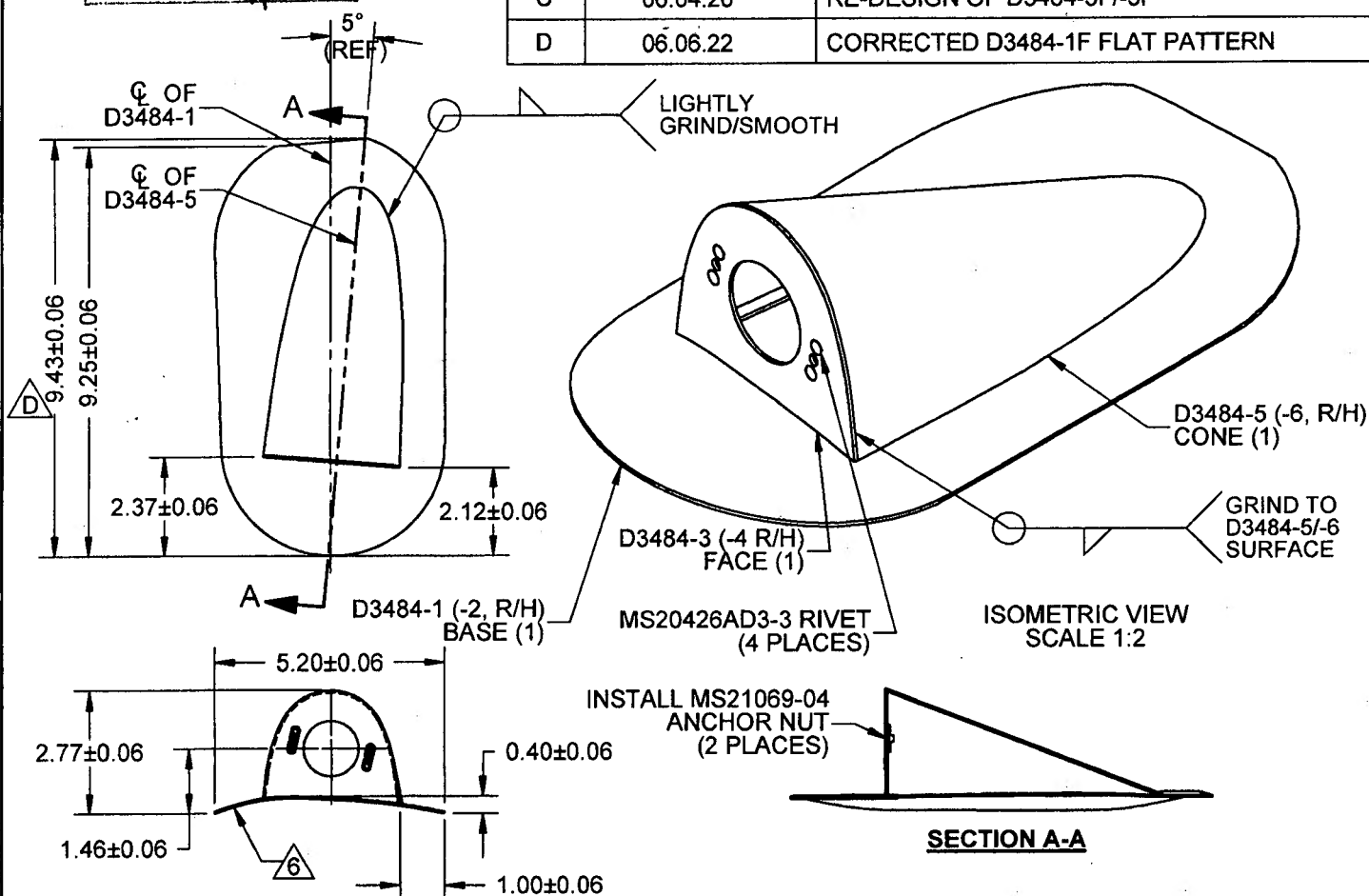
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

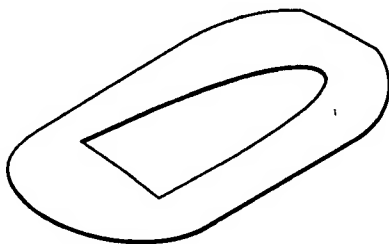
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H) SHOP COPY
	1	D3484-2	BASE (R/H) RETURN TO
1		D3484-3	FACE (L/H) ENGINEERING
	1	D3484-4	FACE (R/H) UNCONTROLLED COPY
1		D3484-5	CONE (L/H) SUBJECT TO AMENDMENT
	1	D3484-6	CONE (R/H) WITHOUT NOTICE
4	4	MS20426AD3-3	RIVET WORK ORDER
2	2	MS21069-04	ANCHOR NUT NO. 30162

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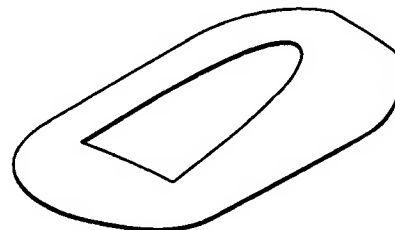
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3484	REV. D SHEET 2 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:2



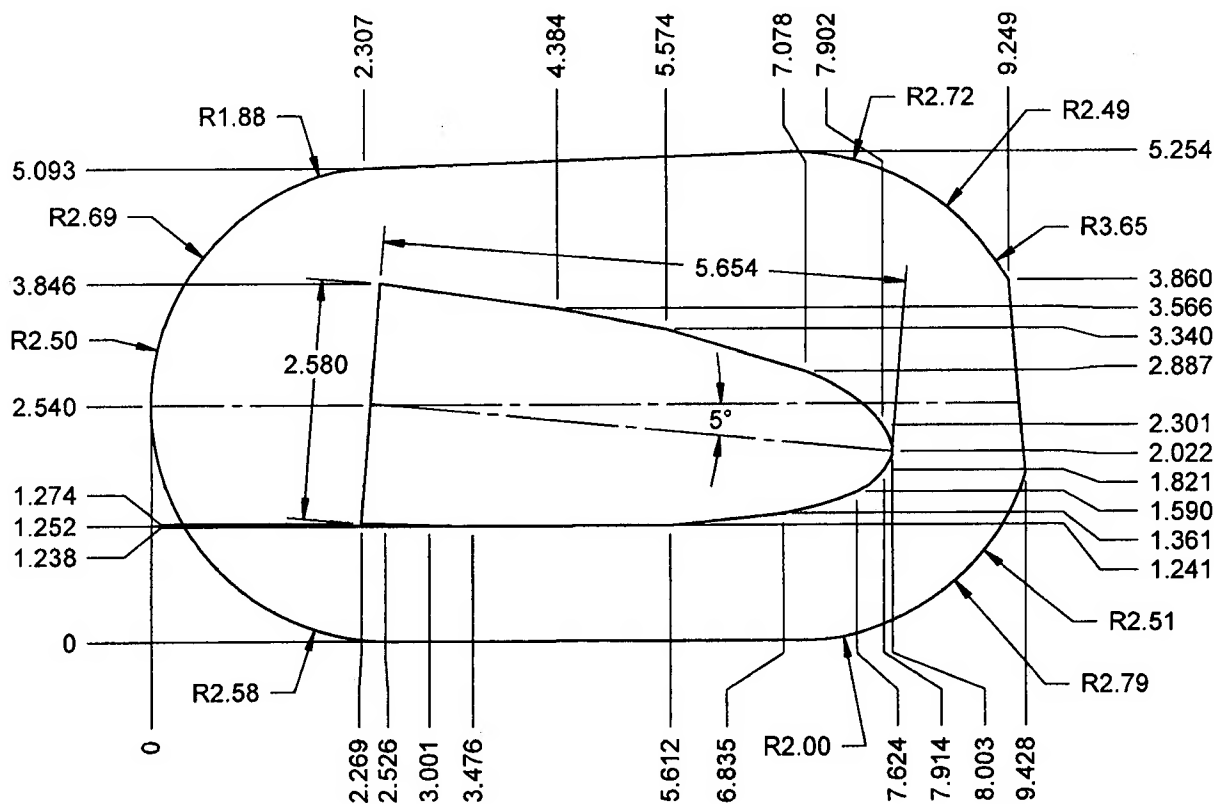
D3484-1 BASE, L/H



D3484-1 BENDING DETAIL
(D3484-2 OPPOSITE)
(MAKE FROM D3484-1F)



D3484-2 BASE, R/H



D3484-1F BASE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

06-08 SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

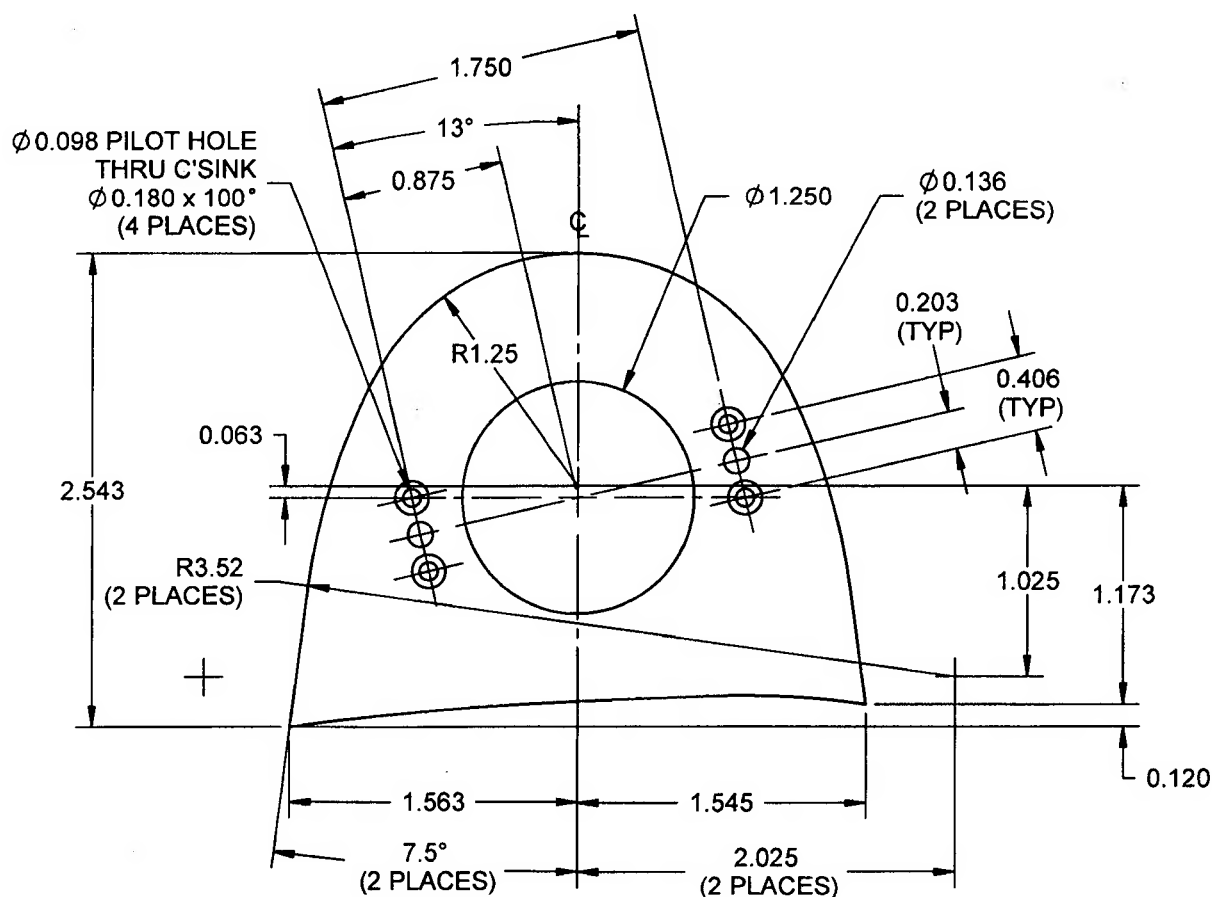
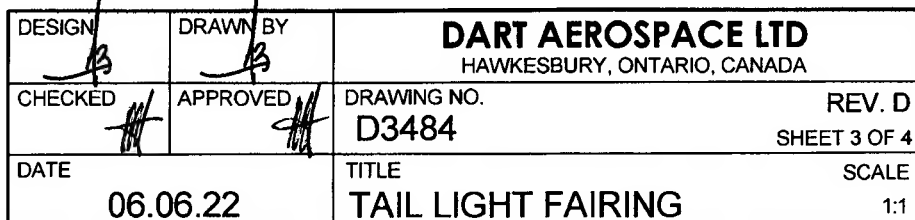
WITHOUT NOTICE

WORK ORDER

NO. 30763

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RELEASED

06.08.17

D3484-3 L/H FACE (-4 R/H, OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

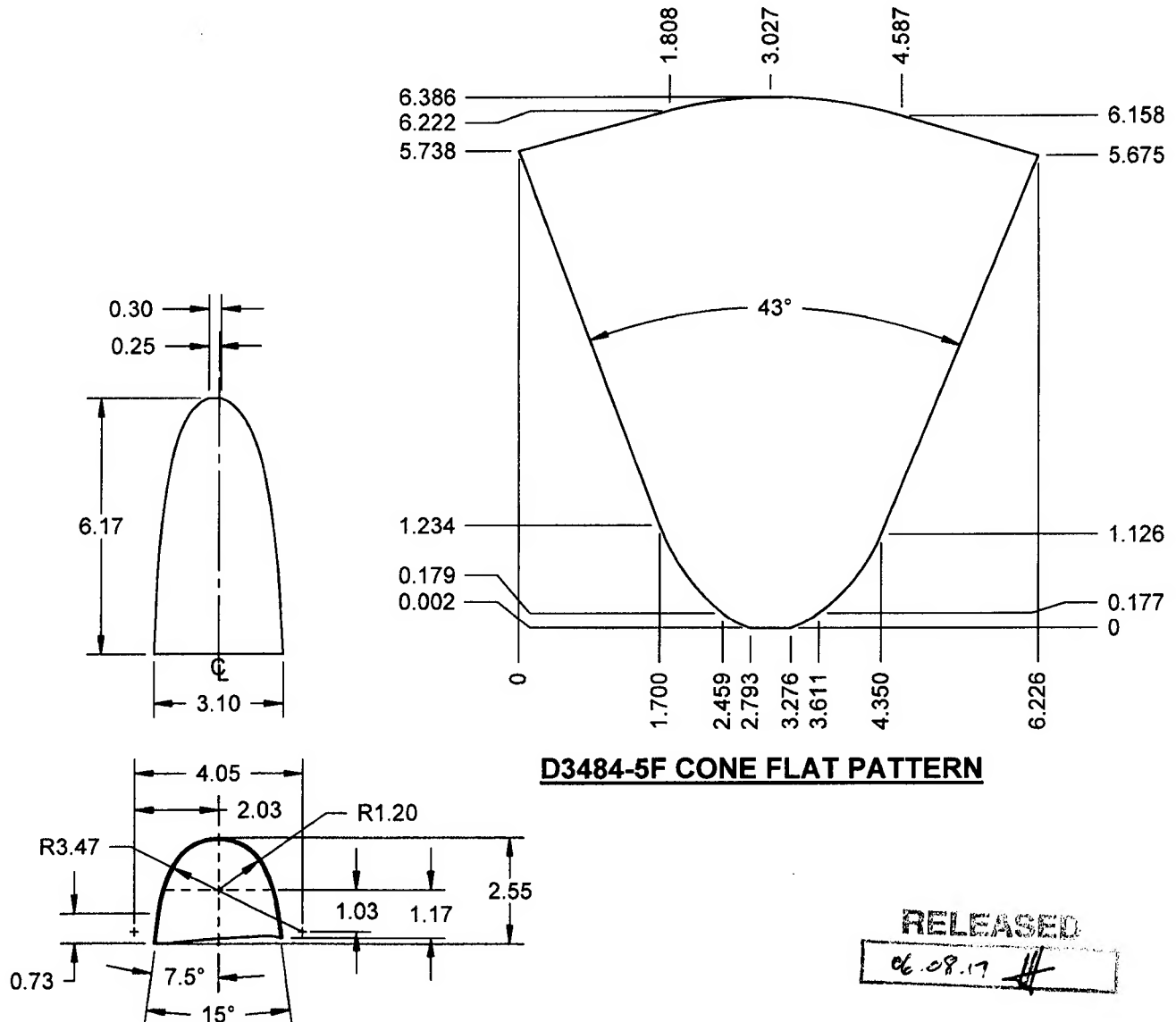
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:4

**D3484-5F CONE FLAT PATTERN****RELEASED**06.08.17 *H***D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)
(MAKE FROM D3484-5F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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